

Date: Monday, 12/5/2005 9:25:27 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BAR
Job Number	: 25101		Part Number	: D3197041
Estimate Number	: 10390		Drawing Number	: D3197 REV A1
P.O. Number	: N/A		Project Number	: N/A
This Issue	: 12/5/2005 S.O. No. : P/A		Drawing Revision	: A1
Prsh Rev.	: NC		Material	: N/A
First Issue	: 12/5/2005 Type : MACHINED PARTS		Due Date	: 12/20/2005 Qty: 20 Um: Each
Previous Run	: 24132			
Written By	<u>See comment below</u>			
Checked & Approved By	<u>See comment below</u>			
Comment	: Est Rev: A New Issue 05-11-08 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M7075T73R1000	7075-T73 Round Bar 1" OD	
		Comment: Qty.: 2.5410 f(s)/Unit Total : 50.8200 f(s) Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD (M7075T73R1.000) 145.5 Identify for D3197-1 118600 Batch: M19052 437	<i>mt 05/12/06 20</i>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 29.125" long	<i>mt 05/12/06 20</i>
3.0	LATHE CONV. 5.0b	CONVENTIONAL LATHE	
		Comment: CONVENTIONAL LATHE Turn To Length and Chamfers as per Dwg D3197	<i>mt 05/12/06 20</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>mt 05/12/06 20</i>
5.0A	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-face ends to length per Dwg D3197 2-Machine D3197-1 as per Folio FA340 and Dwg D3197	<i>EP 05/12/07 20</i>
		3-Deburr	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:25:36 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25101

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ED 05/12/04 20

7.0 QC8

SECOND CHECK



Comment: SECOND CHECK

MK 05/12/10 20

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 1 02/11/05 1 20

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

ML 05/12/03 / 20

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 D26905

Lanyard ass'y



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2690-5 Lanyard B24959
B25104

12.0 D32421

Tag



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D32421 TAG B25105

DL 05/10/04

13.0 AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:25:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25101

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12 AN960JD10 Washer 15519 M 19413

14.0

DARS004

Pip Pin



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 DARS-004 Pip Pin M19048X6, M19439X4, M19440X30

DL

15.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21042L3 Nut (or -3) M17632

16.0

MS27039124

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039-1-24 Screw M3283

M19391

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3197-041 as per Dwg D3197

DL 06/01/05 20

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PTO

06-01-05 20

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

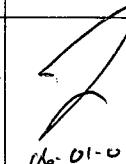
Location: 94

10 06/01/05

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-05	17	Wrong washers were installed.	 06/01/05	& Remove AN960-10 and replace with AN96050-10 as per Dwg.	S/B 06/01/05 >	 06-01-05	 06/01/05	 06-01-05

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:25:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25101

Part Number: D3197041

Job Number:



Seq. #:	Machine Or Operation:	Description :
20.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Inspection Level 21 548 06/01/06 120

28



06/01/06

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Bar	Part Number:	D3197-1
Inspection Dwg: D3197	Rev: A1	Page 1 of 1

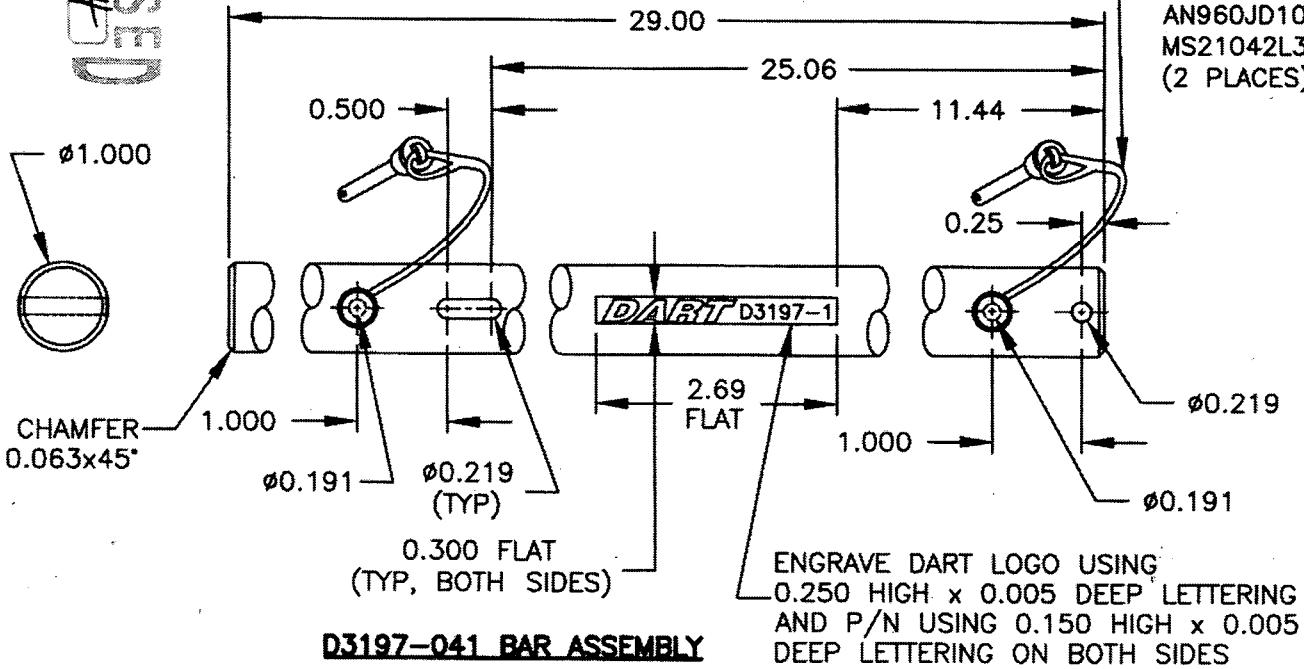
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>SP</i>	Audited by:	<i>MS</i>	Prototype Approval:	N/A
Date:	<i>05/12/06</i>	Date:	<i>05/12/06</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	

RELEASED
03.10.10



A1 D3242-1 TAG (1)

DARS-004 PIP PIN (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)

DART

© DART 2003

DESIGN		DRAWN BY	DART AEROSPACE LTD		
CHECKED	APPROVED	DRAWING NO.		REV. A	
DATE		D3197		SHEET 1 OF 1	
03.07.01		A	03.07.01	NEW ISSUE	
A1	04.01.12			ADD D3242-1 TAG	

D3197-1 BAR

- MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) Ø1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- POSSIBLE SUPPLIER FOR DARS-004 PIP PIN: REID TOOL SUPPLY.
IT IS ACCEPTABLE TO REPLACE WITH ANY STAINLESS STEEL DOUBLE-ACTING QUICK-RELEASE PIN
WITH A Ø0.188 DIAMETER PIN, 1.8"-2.0" GRIP LENGTH, MIN. OF 200 lbs PULL-OUT
STRENGTH, AND MIN. OF 5150 lbs DOUBLE SHEAR.
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDEX (4.3.5.6) PER DART QSI 005 4.3
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER
END OF THE BAR